

Date: Wednesday, 3/12/2008 1:42:13 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEB
Job Number : 37863	
Estimate Number : 10482	
P.O. Number :	Part Number : D2923
This Issue : 3/12/2008 S.O. No. :	Drawing Number : D2923 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : A
Previous Run : 31565	Material :
Written By :	Due Date : 3/28/2008 Qty: 6 Um: Each
Checked & Approved By : <u>AA 08 03 12</u>	
Comment : Est. B 02.07.26 Updated Location RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

D2600-5-108 Extrusion 'I Beam' thin

Batch: 21985

SL 8-3-14

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Cut D2600-5 Extrusion to length as per Dwg D2923.

Deburr ends

SL 8-3-14

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Drill pilot holes in web as per Dwg D2923 using drill jig DT8481

2- Open holes to finish size as per Dwg D2923.

3- Deburr

SL 8-3-14

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08 03 17 (6)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08 03 17

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: NO Date: 08/03/19

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 37863

Part Number: D2923

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 8-3-17

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LG*

am

08-03-17

(6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DP 08/03/17

Job Completion



mi 2008/3/17

(6)

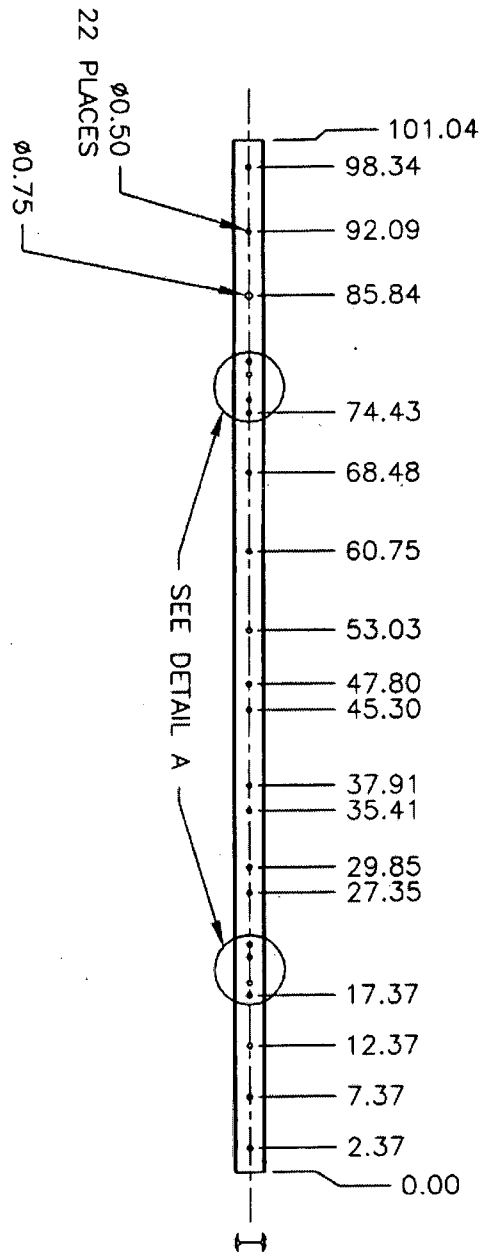
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

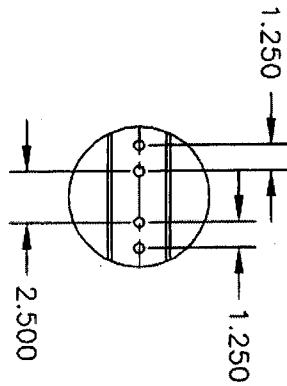
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL A
SCALE 1:9



MAKE FROM D2600-5 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
REFIT TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO 37863

RELEASED
00.05.11

DESIGN	RF	DRAWN BY	RF	APPROVED	99.10.14	A
CHECKED		DRAWING NO.	D2923	TITLE	WEB	NEW ISSUE
DATE	99.10.14	SCALE	1:18	SHEET	1 OF 1	REV. A
DART Aerospace USA, INC. BELLEVUE, WA						



